Work Order ID 111170

January-09-14 12:37:35 PM

111170

~~PRELIMINARY ISSUE~~

Item ID: D4634-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Aft, Center Ceiling Panel **Stop** *NS2*

Start Date: 09/01/2014 **Start Qty:** 1.00 *1*

Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** NP/MLJ **Date:** 14-01-09 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	DAS	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**	27 9-89								
D4634	~~PD2~~ E Rev E									
100			0.00							
100	HAND FINISHING THERMOFORMING						x1			DL 14/01/12
Thermoform	**Memo**		0.00							
Thermoforming Machine	Cut Blanks									
105			0.00							
105	Dry Material						x1			DL 14/01/12
HandThermo	**Memo**		0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE									

Temp: 245° F

Time IN: 5:00 pm 14/01/11

Time OUT: 6:00 am 14/01/12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D4634-5 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Aft, Center Ceiling Panel
Start Date: 09/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE					x1			WL 14/01/17
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4634-5 and Folio FTA146								
	Dwg. Rev. E								
	Folio Rev. B								
	Visually inspect for proper formation and texture								
130		0.00							
130	HAND FINISHING THERMOFORMING					(x1)			14/01/21
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140						(1)	SAD		14/01/24
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Item ID: D4634-5 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Aft, Center Ceiling Panel
Start Date: 09/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00				1			
150									
QC	**Memo**	0.00							
Quality Control									
160		0.00							
160	Packaging								
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	**Memo**	0.00							
Quality Control									

14-01-24

POSITIVE RECALL
EFFECTIVE _____ AUTH
RELEASED _____ DATE _____

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐
Large Fab	☐	Composite	☐	Supplier	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐	Centre Not Concentric
☐	Cracks
☐	Crimp/Kink/Ripple/Wave
☐	Cuffs
☐	Crushing
☐	Heat Treat
☐	Inspection Strip in Tube
☐	Marks/Chatter
☐	Turning Sequence
☐	Wave/Twist in Tube

General

☐	Bend
☐	BOM/Route
☐	Broken/Damage/Defect
☐	Burrs
☐	Contamination
☐	Countersink
☐	Cut Too Short
☐	Drawing
☐	Drill Holes
☐	Finish
☐	Fit/Function
☐	Folio/Program
☐	Grain
☐	Hardware
☐	Inspection Incomplete/Unqualified
☐	Instructions Incomplete/Unclear
☐	Misaligned/off center
☐	Mislabeled
☐	Misread
☐	Off-set
☐	Out of Calibration
☐	Out of Sequence
☐	Outside Dimensions
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Positioned Wrong
☐	Power Loss/Surge
☐	Pressure/Forced
☐	Set-up
☐	Temperature/Cure
☐	Weld
☐	Wrong Stock Pulled
☐	Other

Picklist Print

January-09-14 12:37:40 PM

Work Order ID: 111170 *111170*

Parent Item: D4634-5 *D4634-5*

Parent Item Name: Aft, Center Ceiling Panel

Start Date: 09/01/2014 **Required Date:** 24/01/2014

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 13/07/09 DL verf:DD IPP Rev C Dwg. Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,861.260	12.93	16			

MLEXS.093-F6006-07

GE PLASTICS LEXAN SHEET

**

Location	Loc Qty	Loc Code
MAT023	1861.26	
114459	229.26	
123105	38	
124501	1594	

DL 14/a/12

16 sf DL

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
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☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
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General

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☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

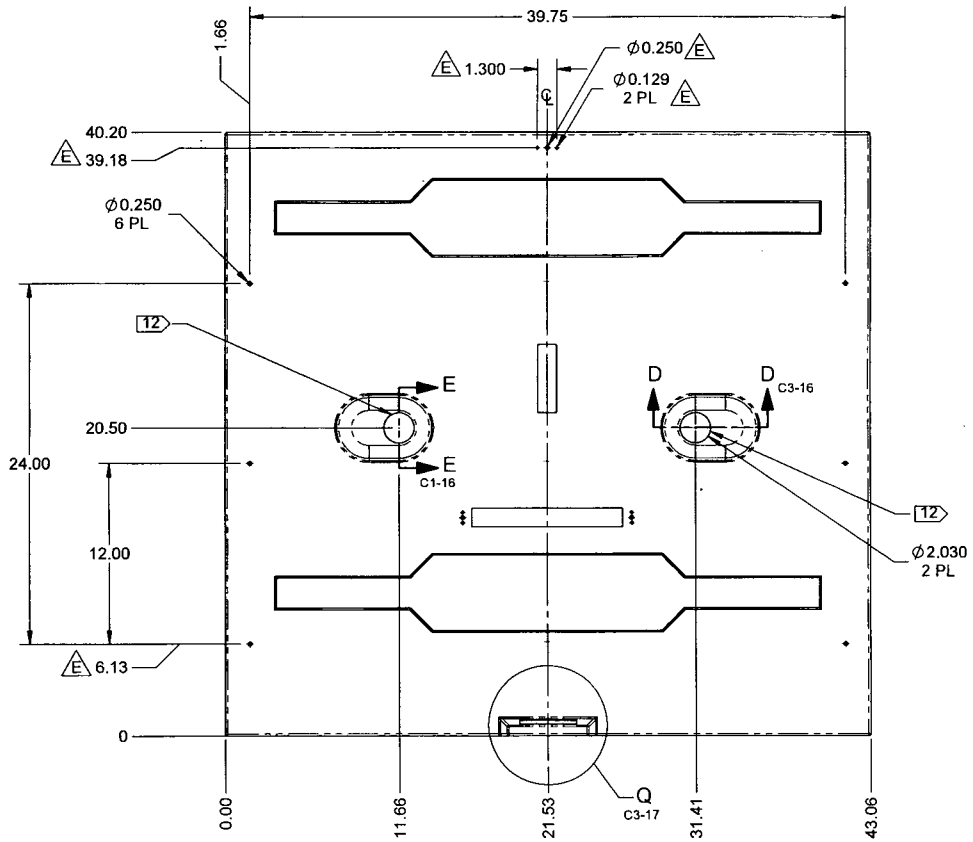
DART AEROSPACE LTD

Description:	PANEL	Work Order:	111170
Inspection Drawing:	D4634	Rev: PE1	Part Number: D4634-5

INSPECTION SHEET

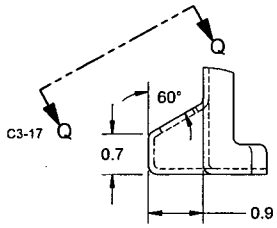
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.50	+/- 0.030	21.47	✓		tape	JFAB-21
4.55	+/- 0.030	4.52	✓		tape	"
14.50	+/- 0.030	14.50	✓		tape	"
13.88	+/- 0.030	13.85	✓		tape	"
1.25	+/- 0.030	1.24	✓		Vern	SFAB-08
10.05	+/- 0.030	10.08	✓		tape	"
11.25	+/- 0.030	11.25	✓		tape	"
3.80	+/- 0.030	3.80	✓		Vern	SFAB-08
0.63	+/- 0.030	0.66	✓		Vern	SFAB-08
20.50	+/- 0.030	20.50	✓		tape	
11.66	+/- 0.030	11.66	✓		tape	
Ø 2.030	+0.002 -0.001	Ø2.020			Vern	SFAB-08
Ø 0.250	+0.005 -0.001	Ø0.250	✓		Vern	SFAB-08
Ø 0.098	+0.004 -0.001	Ø0.098	✓		Vern	SFAB-05
12.00	+/- 0.030	12.030	✓		tape	
24.00	+/- 0.030	24.00	✓		tape	
39.75	+/- 0.030	39.75	✓		tape	
21.53	+/- 0.030	21.50	✓		tape	

Measured by: SAD	Checked By: SAD	QC inspector:	Engineering Approval (*if necessary*):
Date 14/01/24	Date 14/1/24	Date	Date

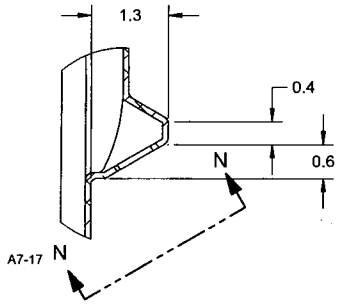


D4634-5 AFT, CENTER CEILING PANEL
AUXILIARY VIEW

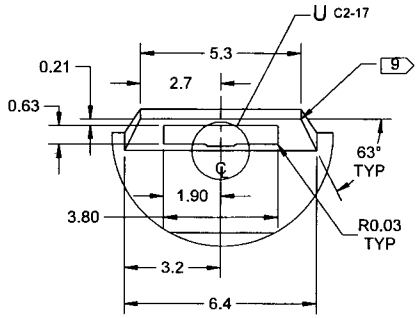
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DRAWN	RF		
CHECKED	JC	DRAWING NO. D4634	REV. PE1
MFG. APPR.			SHEET 15 OF 17
APPROVED		TITLE CENTER CEILING PANELS	SCALE NTS
DE APPR.			
DATE 14.01.09		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



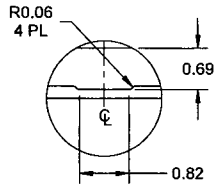
DETAIL P B3-14
SCALE 2X



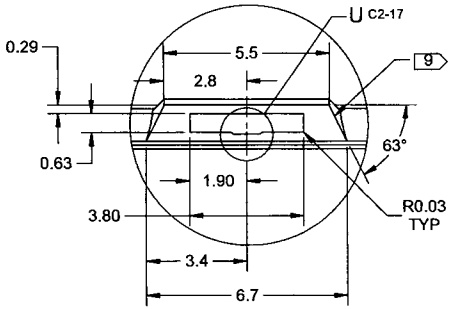
DETAIL M C3-10
SCALE 2X



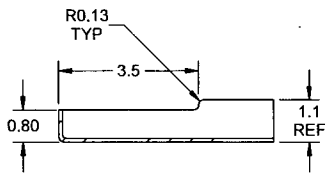
DETAIL Q B4-15 D8-17
SCALE 0.5X



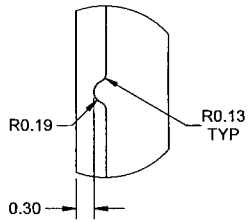
DETAIL U B7-17 D3-17
SCALE 0.5X



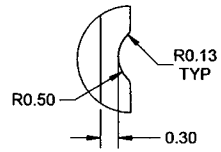
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SCALE 0.5X



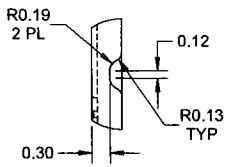
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10 C3-10 B2-12
SCALE 4X



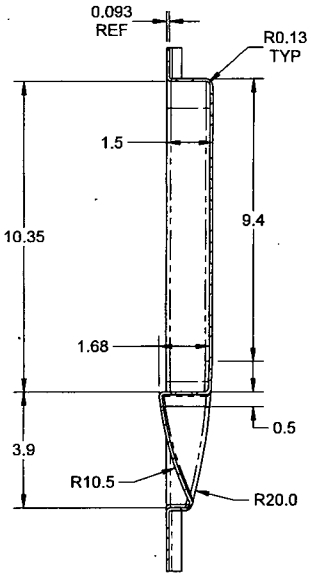
DETAIL S B3-10 C2-12
SCALE 4X



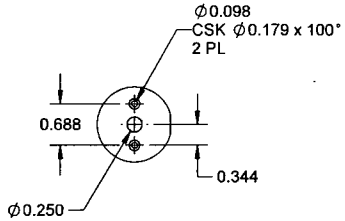
DETAIL T C2-14
SCALE 4X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4634 — REV. PE1 — SHEET 17 OF 17
MFG. APPR.		
APPROVED		TITLE: CENTER CEILING PANELS — SCALE: NTS
DE APPR.		
DATE	14.01.09	

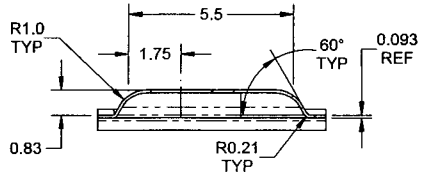
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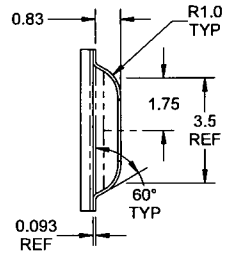
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SCALE 4X



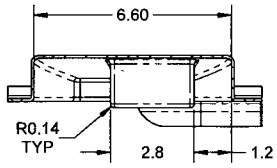
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SCALE 4X



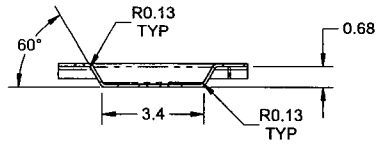
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SCALE 2X



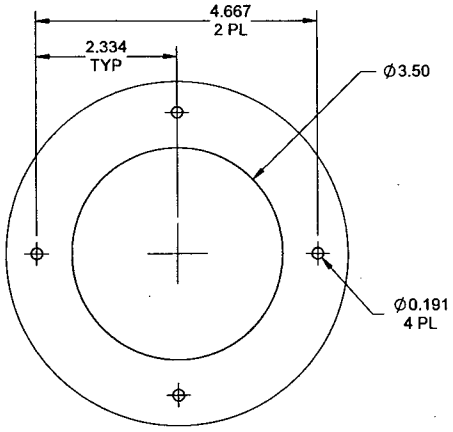
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SCALE 4X



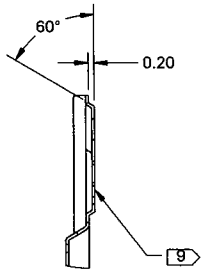
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SECTION J-J B6-13
SCALE 2X



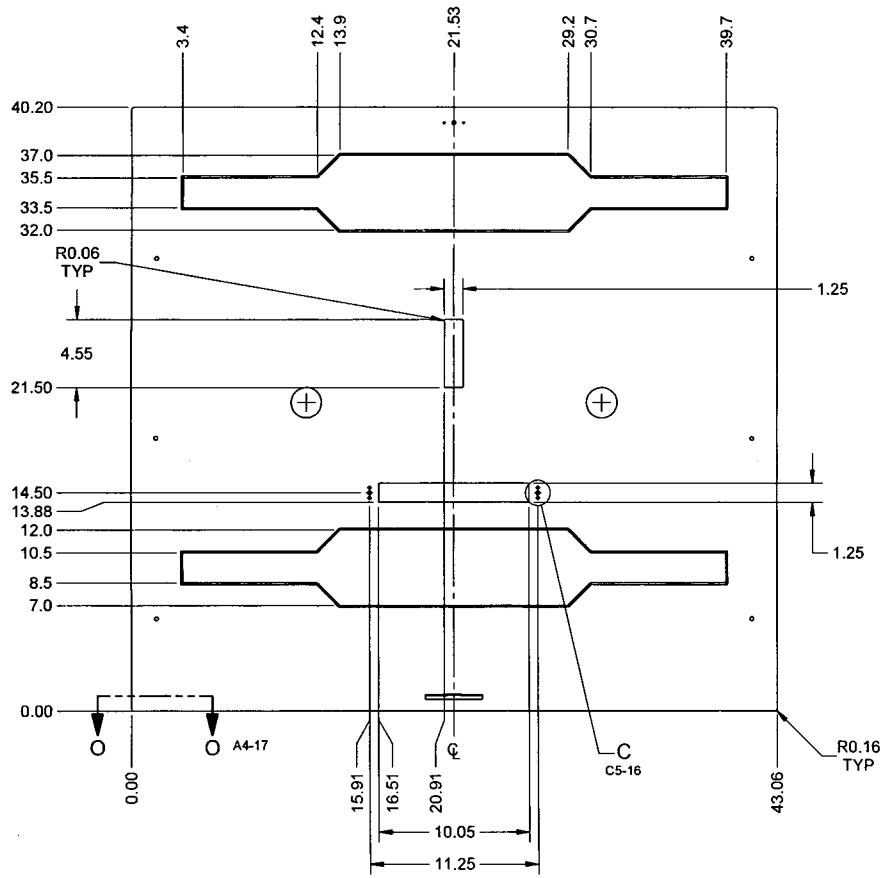
Ⓔ **DETAIL B** B7-10
SCALE 4X
2 PL

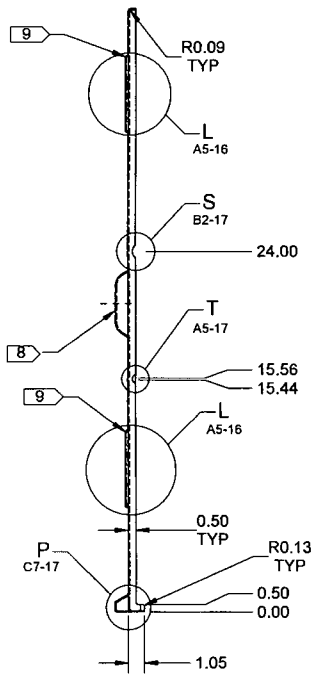


DETAIL L B2-13 C2-13 B2-14 C2-14
SCALE 4X
TYP

DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. PE1
MFG. APPR.		D4634	SHEET 16 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
DATE	14.01.09		

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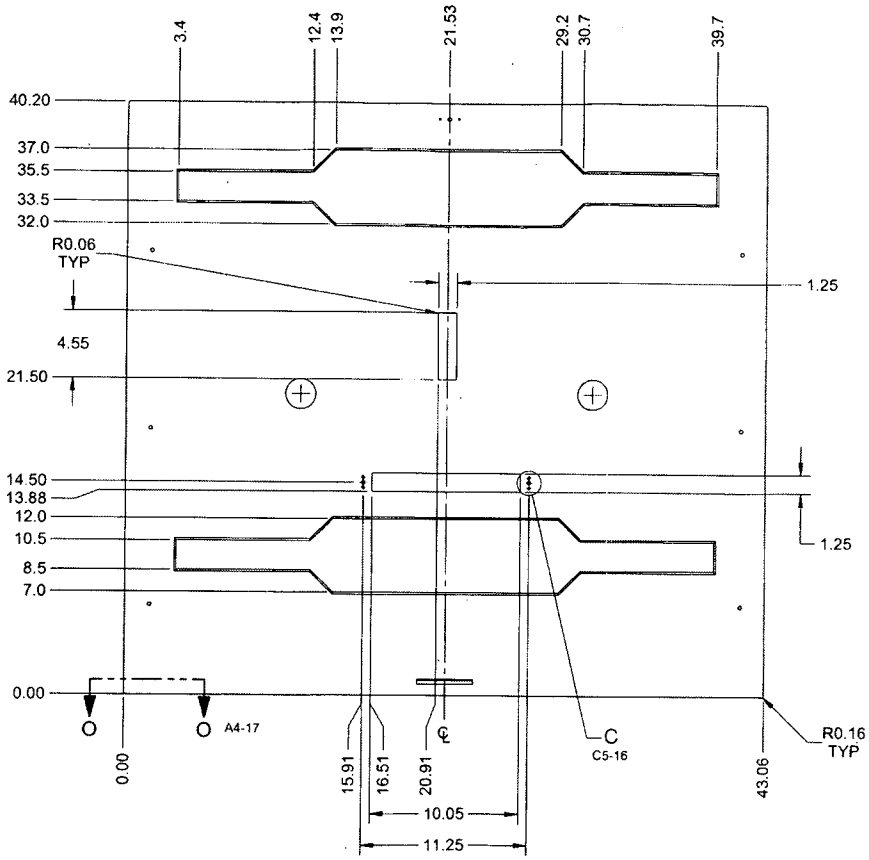


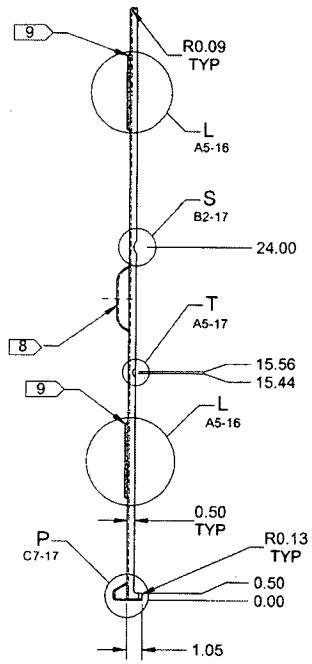
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 7.39 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-5 PER TOOL DT9838
11) THERMOFORM PER QSI 022 USING DT9846 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE ϕ2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-5 AFT, CENTER CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4634 REV. PE1
MFG. APPR.		SHEET 14 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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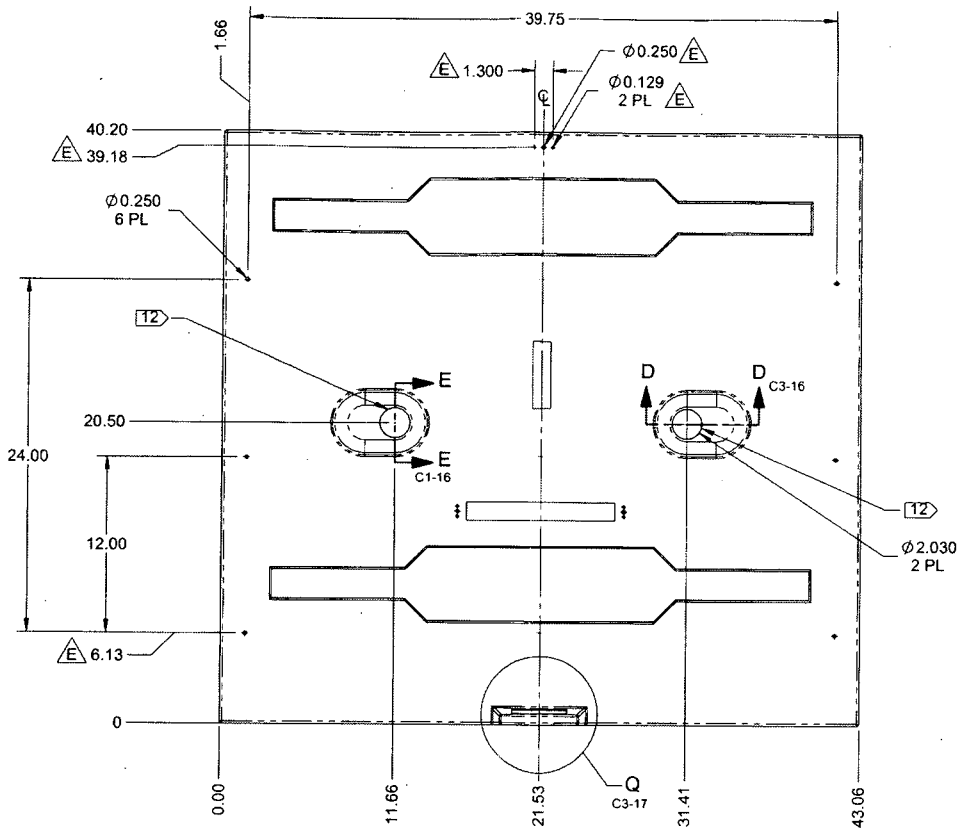
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 7.39 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-5 PER TOOL DT9838
11) THERMOFORM PER QSI 022 USING DT9846 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE ⌀2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-5 AFT, CENTER CEILING PANEL

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2014 -01- 22

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.		D4634	SHEET 14 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
DATE	14.01.09		

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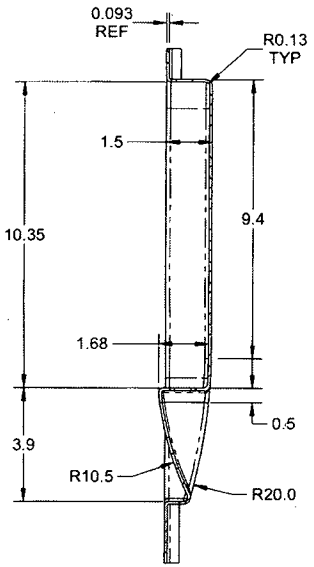


D4634-5 AFT, CENTER CEILING PANEL
AUXILIARY VIEW

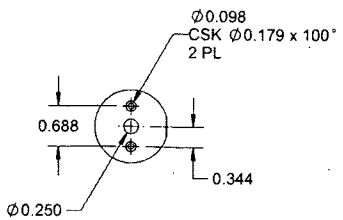
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2014 -01- 22

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4634 REV. E
MFG. APPR.		SHEET 15 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

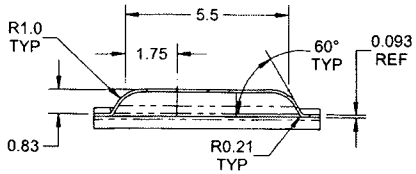
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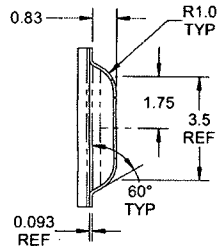
SECTION G-G C5-11
SCALE 4X



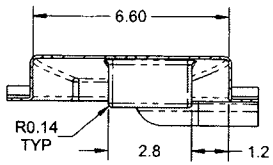
DETAIL C B7-10 B4-12 B4-14
SCALE 4X



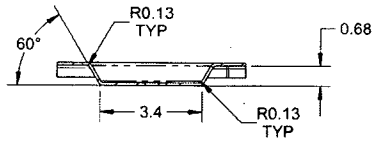
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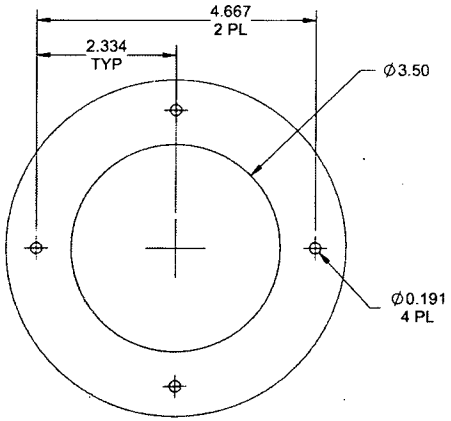
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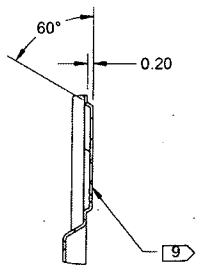
SECTION H-H C5-11
SCALE 2X



SECTION J-J B6-13
SCALE 2X



E **DETAIL B** B7-10
SCALE 4X
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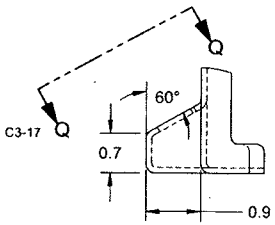


DETAIL L B2-13 C2-13 B2-14 C2-14
SCALE 4X
TYP

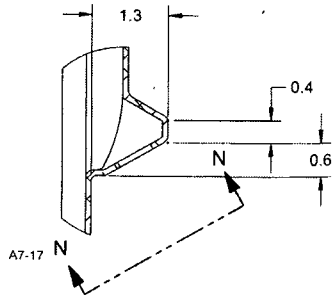
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.		D4634	SHEET 16 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
DATE	14.01.09		

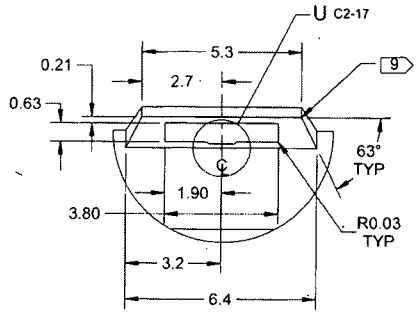
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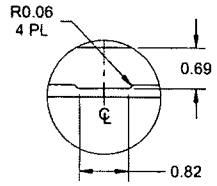
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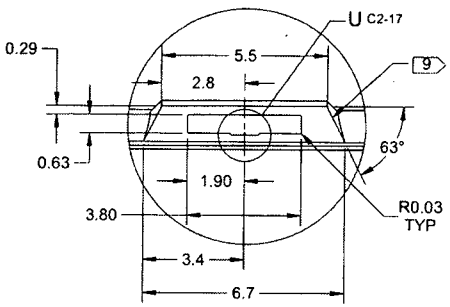
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SCALE 2X



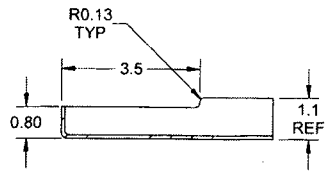
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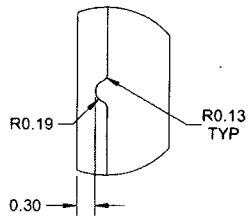
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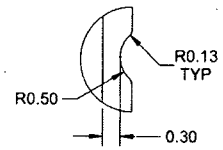
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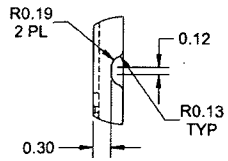
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10 C3-10 B2-12
SCALE 4X



DETAIL S B3-10 C2-12
SCALE 4X



DETAIL T C2-14
SCALE 4X

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DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4634 REV. E
CHECKED	DC	SHEET 17 OF 17
MFG. APPR.		TITLE CENTER CEILING PANELS SCALE NTS
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DE APPR.		
DATE	14.01.09	

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